



Dart Aerospace Ltd.
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Tel (613) 632-5200

D4330-041
Job Sheet 179705



Part No: D4330-041

Job Qty: 2 ea

Part Name: Airframe Bracket Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/6/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEETS 1,2,3 IPP REV:A 11.08.18 new issue DD Verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Waterjet		SC 18/06/24
100	Waterjet	2 pcs	7/6/18	7/6/18	0.00	0.21	Waterjet1		SC 18/06/24
110	QC	2 pcs	7/6/18	7/6/18	0.00	0.00	QC2 Waterjet-3		SC 18/06/24
120	QC	2 pcs	7/6/18	7/6/18	0.00	0.00	QC8-4		38
130	Brake NC	2 pcs	7/6/18	7/6/18	0.17	0.53	Brake NC 2		9-89 JB
140	QC	2 pcs	7/6/18	7/6/18	0.00	0.00	QC6		38
150	HandFinish	2 pcs	7/6/18	7/6/18	0.00	0.13	HandFinish1		SA 18-07-18
160	Powdercoat	2 pcs	7/6/18	7/6/18	0.00	0.08	Powdercoat3		18-7-18
170	QC	2 pcs	7/6/18	7/6/18	0.00	0.00	QC3		9-89
180	Small Fab	2 pcs	7/6/18	7/6/18	0.00	0.17	Small Fab-6		DAS 38
190	QC	2 pcs	7/6/18	7/6/18	0.00	0.00	QC5		DAS 38
200	Packaging	2 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-2		6
210	QC21-SA	2 Ea	7/6/18	7/6/18	0.00	0.00	QC21		9-89

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.6048 sf (.3024 ea)	90-Start up Operation	
D3622-1	Ball Stud	2 Ea (1 ea)	180-Small Fab	5081667
MS21042L5	Nut	2 Ea (1 ea)	180-Small Fab	5058178
NAS1149D0563J	Washer	2 Ea (1 ea)	180-Small Fab	5068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	1	317	0
180-Small Fab	D3622-1	2	40	0
	MS21042L5	2	558	0
	NAS1149D0563J	2	1,919	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
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Completed By _____

id / Supervisor _____

al Verification _____

Coordinator _____

approval _____

ed Wrong _____

Dimensions _____

ider tolerance _____

orrect _____

/Missing _____

red _____

Drawing _____

Finish _____

Misread _____

Turning Sequence _____

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/For ☐	
Design ☐	Operator ☐	Bending ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not C ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/R ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

Container No: S083581
 Part: D4330-041
 Job No: 179705
 Serial No/Batch: S083581
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 06/25/18

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179705

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>SE</u>		Audited by: <u>38</u> <u>9-88</u>		Preliminary Approval:		
Date: <u>18/06/24</u>		Date: <u>JUN 26 2018</u>		Date:		
Rev	Date	Change			Revised by	Approved
A	11.10.13	New Issue			KJ	<u>JA</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____	